

Date: Monday, 2/11/2008 2:12:06 PM
 User: Kim Johnston

Process Sheet

Customer *	CU-DAR001 Dart Helicopters Services		Drawing Name	LUG		
Job Number	37335					
Estimate Number	11019					
P.O. Number	:		Part Number	D27313		
This Issue	2/11/2008	S.O. No. :	Drawing Number	D2731 REV B		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	B		
Previous Run	33995		Material	:		
Written By	:		Due Date	2/26/2008	Qty:	100
Checked & Approved By	:		Um:	Each		
Comment	Est:D 00.05.19 Added inspect level 8, removed P/O for powder coating EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: <u>B33310</u>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut D2423 Extrusion: 0.82" Long
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2731-3 Check for crack while loading into the machine Tumble Debur any rough edges after tumbling
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE Received & inspect for transit damage
5.0	QC3	SECOND CHECK
		Comment: SECOND CHECK dimensional check

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 37335

Part Number: D27313

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

08-03-07

x100

7.0 POWDER COATING

POWDER COATING



m107005

FL 08/03/10

ice

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HL 08-03-10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 469

8/3/10

100x

5x

10.0 QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

108/03/12

Job Completion



mi 2008/3/12

100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37335
Description: Lug	Part Number:	D2731-3
Inspection Dwg: D2731 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

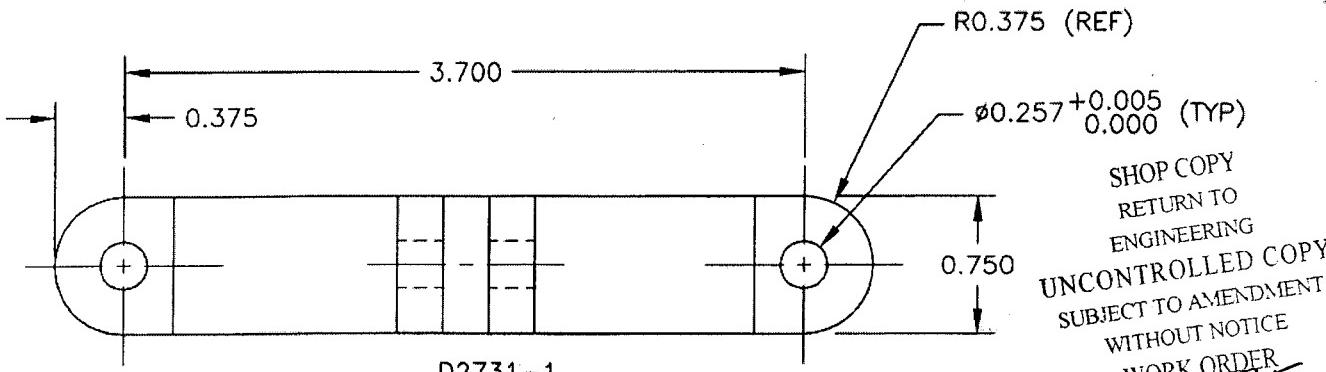
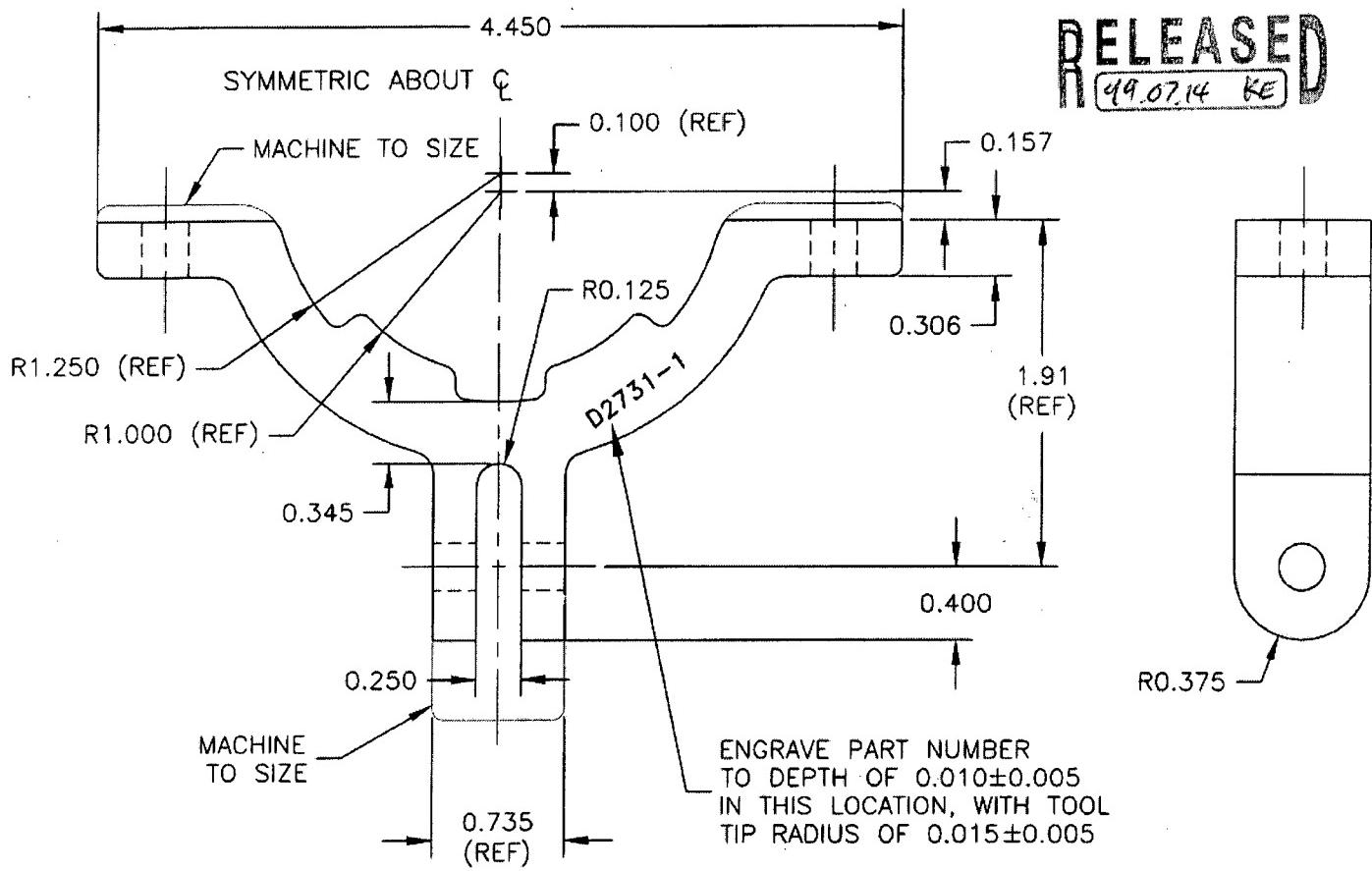
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	EE



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA		
CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4	
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1	
A	98.05.13	NEW ISSUE		
B	99.07.06	REVISED DIMENSIONS		



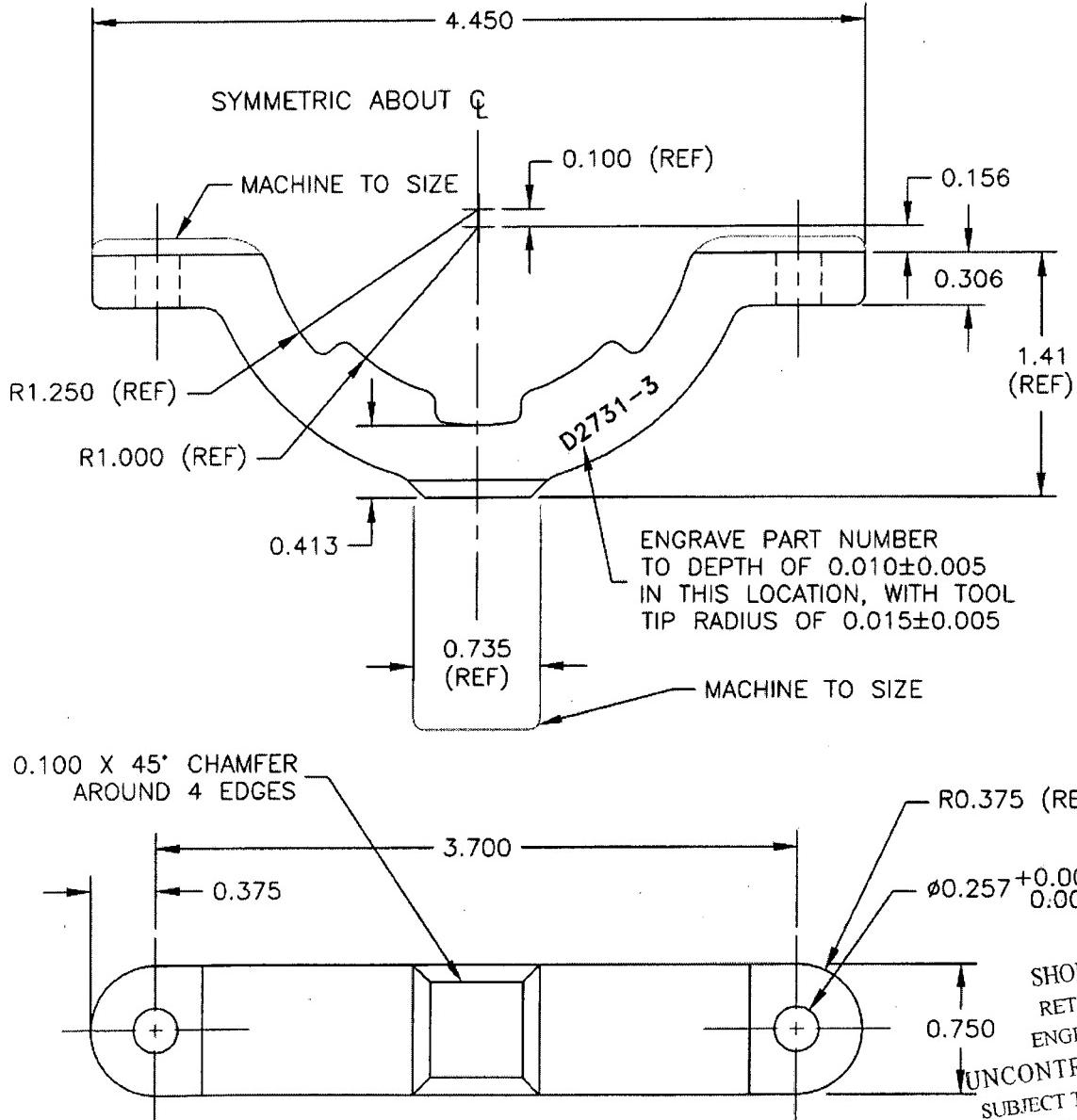
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37335



DESIGN KE	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED KE	APPROVED JF	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
19.07.14 KE

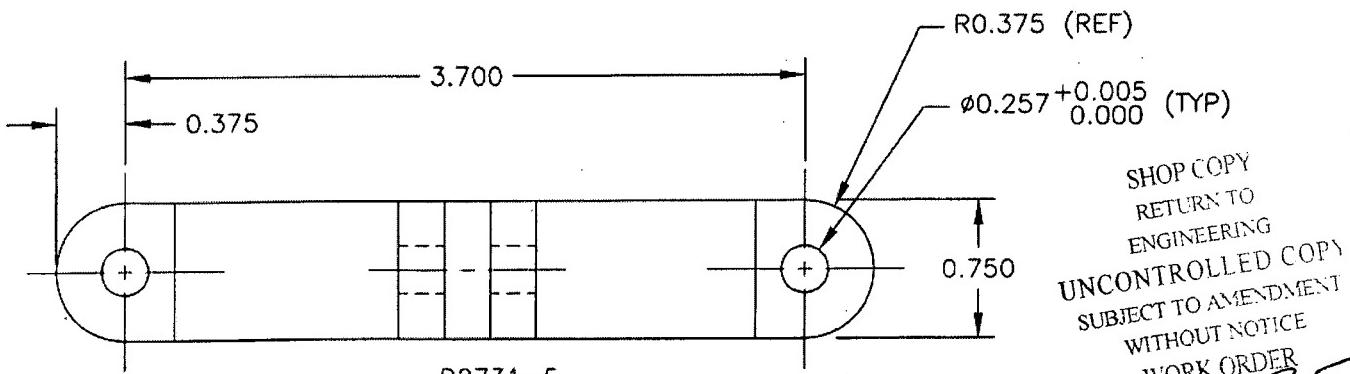
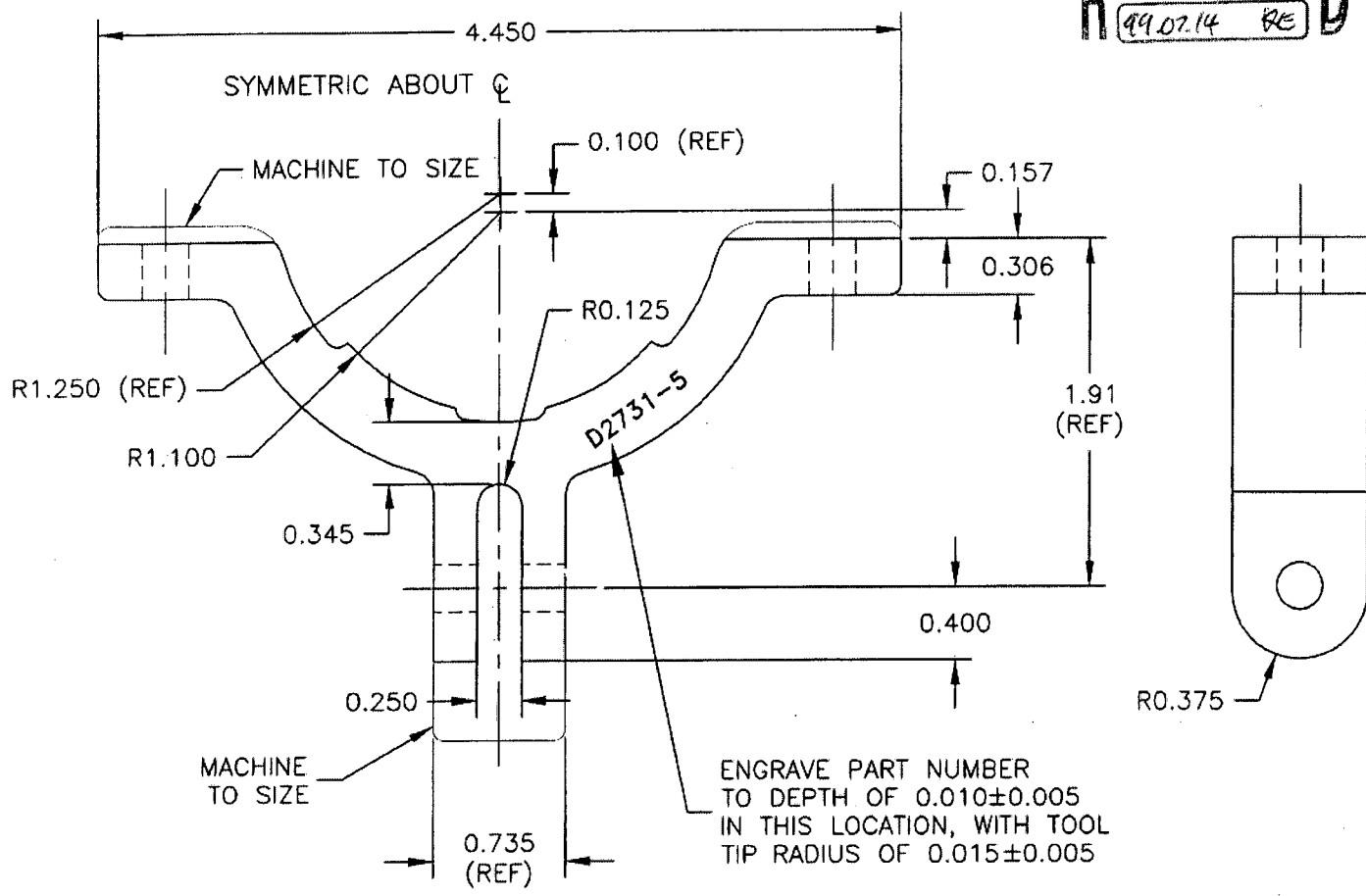


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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>VS</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 3 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 RE

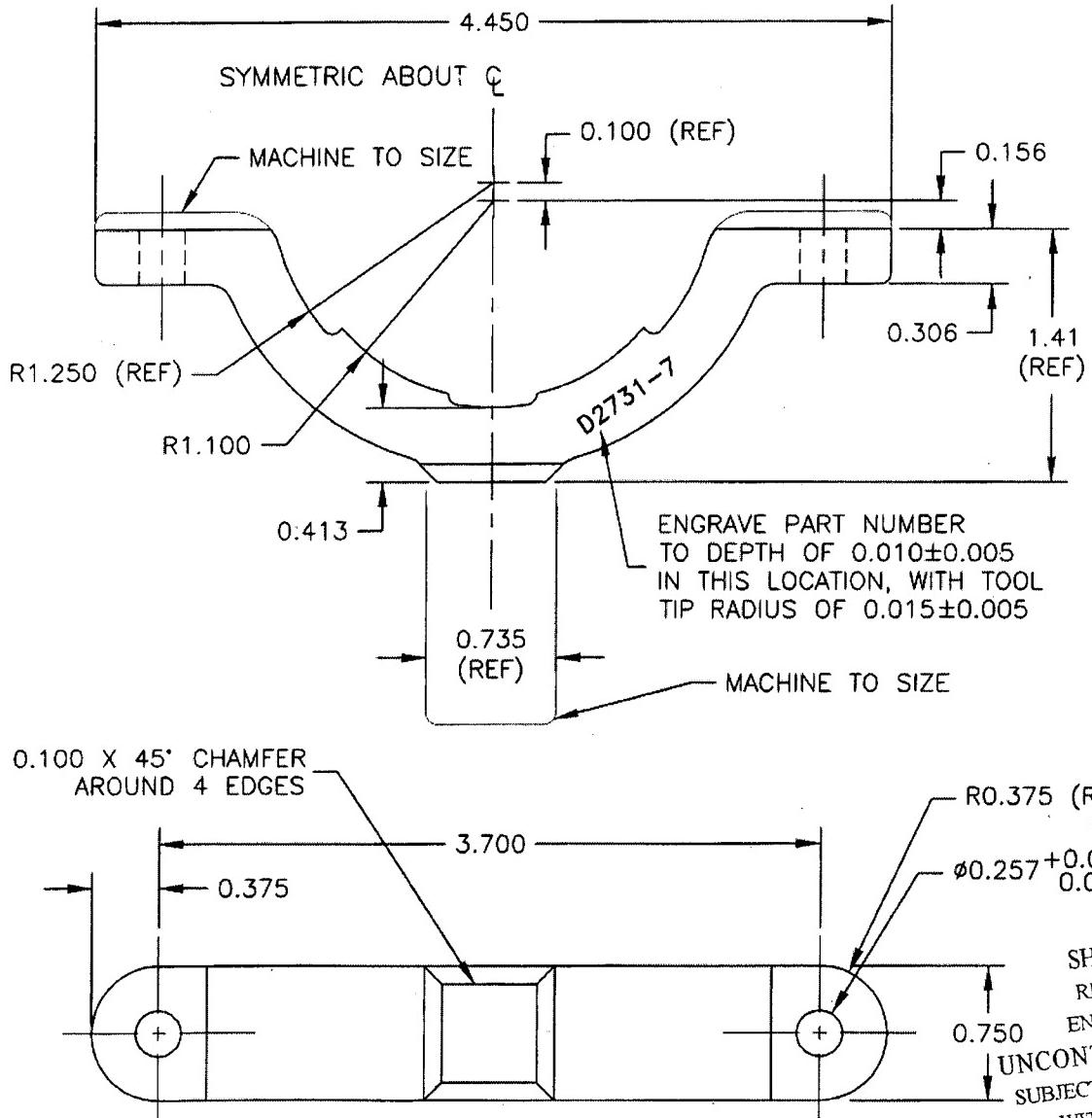


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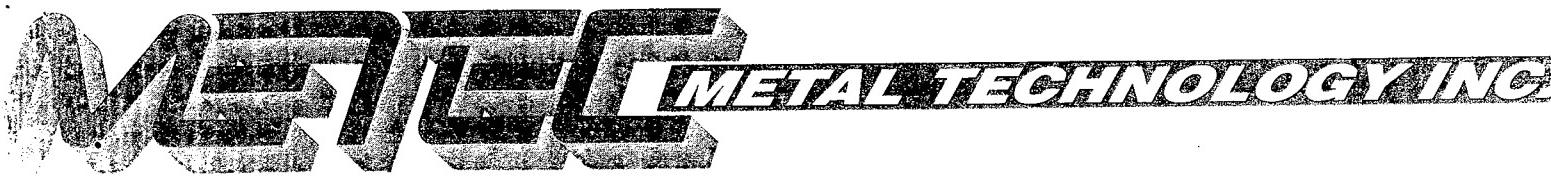


DESIGN KE	DRAWN BY RF	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 KE



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BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

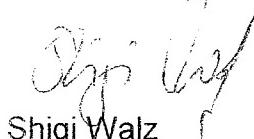
same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
100	D2731-3	Mounting Lug B37335	5679
100	D2731-7	Mounting Lug B37336	5679

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 6, 2008